



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SWA6A-100
Job Sheet 189359



Part No: SWA6A-100

Job Qty: 5 pcs

Part Name: Lower End



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/23/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA6A-100 Rev7 IPP Rev A 17.11.15 New issue

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	5 pcs	2/15/19	2/15/19	0.00	0.50	Bandsaw - 1		
110	NLX 2500SY - B4B	5 pcs	2/15/19	2/15/19	0.00	5.00	NLX 2500SY - 1 - B4B		
120	QC 2	5 pcs	2/15/19	2/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S149084



Part: SWA6A - 100

Job No: 189359

Serial No/Batch: S149084

Revision: 7

Inspector:

Exp Date:

Instructions:

Date: 01/29/19

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

Plex 1/23/19 9:18 AM Dart.lajeunesse.marie

QC 21 - SA - 70

Part Op 100 - (Bandsaw) Cut blanks to 5.90".

Descriptions: 110 - NLX (MORI NLX 2500SY LATHE) 1-Machine as per folio FB703 FOLIO REV: _____ DWG REV: _____
2-Deburr

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Identify as per dwg & Stock Location: _____)

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R2.500	17-4 SS H1150 Round Bar 2.500"	2.4500 ft (.49 ea)	100-Bandsaw - 1	5030421

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-H1150-R2.500	2	2	0

Part Specifications

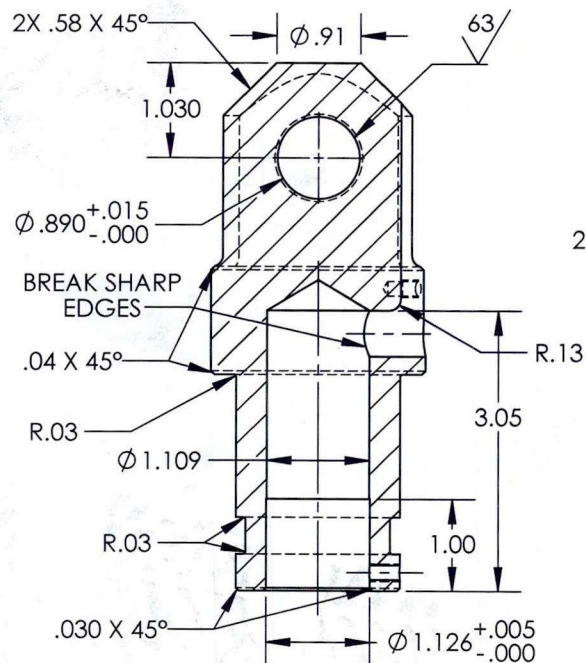
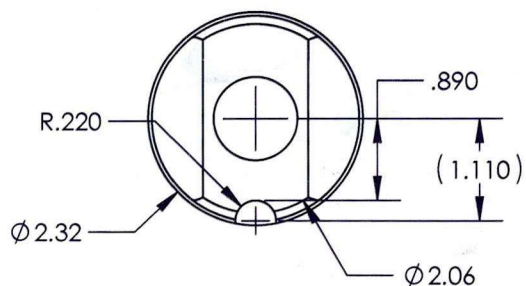
Specifications could not be found.

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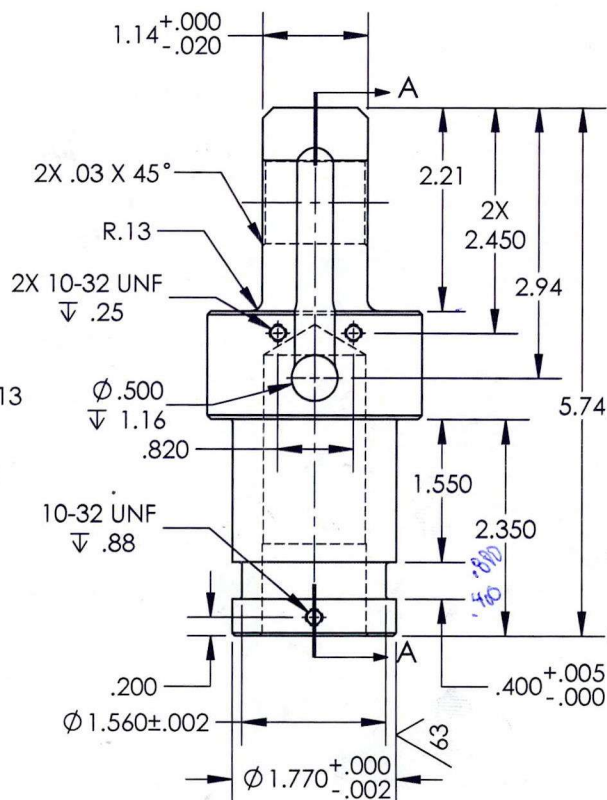
MAT
used
0.991"

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
6		AS DRAWN BY CANAM.			11/15/2012	JAG
7	15-0088	CH'D DIMENSION OF TOP FLANGE WAS 1.14 IS 1.14 +.000 -.020.			4/16/2015	RJC JAG



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189359MCS
190123

DART AEROSPACE	
TITLE LOWER END	
DWG NO. SWA6A-100	REV 7
MATL SS 17-4, H1075, H1150	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 2/1/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA6A-100	1	LOWER END	SS 17-4, H1075, H1150	Ø2-1/2 X 5-7/8

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :		MRB (QSI042)
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:				

DART AEROSPACE LTD		Work Order:	
Description: <u>Lower End</u>		Part Number:	
Inspection Dwg: <u>SWA6A-100</u>		Rev: <u>7</u>	Page 1 of <u>2</u>

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.91	$\pm .01$	.910			Vern LPO	
.58 x 45°	$\pm .01 \times .5^\circ$	.58 x 45°			↓	
1.030	$\pm .005$	1.030			Mic LPO6	
Ø.890	$+ .015 / - .000$	.891			Gage Pin	
.04 x 45°	$\pm .10 \times .5^\circ$	.040 x 45°			Vern LPO	
R.03	$\pm .01$	.031			Rad gage	
Ø1.109	$\pm .005$	1.107			Vern LPO	
R.03	$\pm .01$	.02			↓	
.030 x 45°	$\pm .005 \times .5^\circ$	.030 x 45°			↓	
Ø1.126	$+ .005 / - .000$	1.129			↓	
3.05	$\pm .01$	3.050			H.G.	
R.13	$\pm .01$	.125			Rad gage	
1.00	$\pm .01$	1.000				
R.220	$\pm .005$	.218			Rad gage	
Ø 2.32	$\pm .01$	2.320			Vern LPO	
Ø 2.06	$\pm .01$	2.060			↓	
.890	$\pm .005$	.890			↓	
1.14	$+ .000 / - .020$	1.129			↓	
.03 x 45°	$\pm .01 \times .5^\circ$	.035 x 45°			↓	
R.13	$\pm .01$	.125			Rad gage	
10-32 UNF	G0 - N0 G0	G0				
Ø.500	$\pm .005$	.501			Vern LPO	
.820	$\pm .005$	.821			H.G.	
10-32 UNF	G0 - N0 G0	G0				
.200	$\pm .005$	.201			H.G.	
Ø1.560	$\pm .002$	1.5602			Mic LPO2	
Ø1.770	$+ .000 / - .002$	1.7685			Mic LPO2	
.400	$+ .005 / - .000$	.404			Mic LPO4	
2.350	$\pm .005$	2.350			H.G.	

Measured by: <u>[Signature]</u>	Checked by:	QC Inspector:
Date: <u>14-01-31</u>	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

